

SPLIT

Date: Wednesday, 11/03/2009 2:39:08 PM  
User: Julie Dawson

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 46432 <u>2</u>	
Estimate Number : 10530	
P.O. Number :	
This Issue : 11/03/2009 S.O. No. :	Part Number : D2571
Prsht Rev. : NC	Drawing Number : D2571 REV E
First Issue : 11/03/2009 Type : MACHINED PARTS	Project Number : N/A
Previous Run : 45921	Drawing Revision : E
Written By :	Material :
Checked & Approved By : <u>JULIA 03-11</u>	Due Date : 04/04/2009
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	Qty: 12 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
7075-T7351 8.25X7.75X2.5  
Make from D6101-007 billet for D2571  
Ensure that grain is along 7.75" length  
Batch No: 846412

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. 46432 Double check by: mmf

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2571 & D2572

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Date:  
User:

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Job Number: 46432

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:45  
320°  
4:15

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

SK433

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-04-15



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 410432
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.440	.440			
B	1.745	1.755		1.750	1.747	1.747	1.749		
C	3.495	3.505		3.500	3.497	3.496	3.499		
D	1.745	1.755		1.750	1.748	1.747	1.748		
E	7.990	8.010		8.002	8.004	8.005	8.006		
F	0.490	0.510		.501	.506	.502	.503		
G	0.257	0.262		.259	.258	.258	.258		
H	0.375	0.380		.376	.375	.377	.376		
I	0.490	0.510		.500	.504	.508	.504		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.568	.573	.571	.573		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.494	1.494		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.873		
P	0.115	0.135		.127	.124	.124	.127		
Q	0.115	0.135		.135	.135	.135	.134		
R	0.240	0.260		.252	.250	.250	.252		
S	0.115	0.135		.126	.128	.128	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.959	2.958		
V	0.230	0.250		.242	.235	.236	.237		
W	0.115	0.135		.123	.125	.125	.125		
X	0.308	0.313		.310	.312	.312	.313		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.362	.364	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.632	.631	.630	.632		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.244	.250	.250		
AE	1.375	1.395		1.391	1.395	1.394	1.393	1.387	
AF	0.115	0.135		.135	.126	.128	.130		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.240	.242	.242		
AI	2.000	2.020		2.003	2.003	2.004	2.007	2.003	
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	09/04/05

Audited by:	mf
Date:	04/04/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46432
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		.440	.441	.441	.440		
B	1.745	1.755		1.746	1.750	1.750	1.750		
C	3.495	3.505		3.498	3.500	3.500	3.500		
D	1.745	1.755		1.746	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.001	8.000	8.000		
F	0.490	0.510		.498	.500	.501	.506		
G	0.257	0.262		.258	.258	.259	.259		
H	0.375	0.380		.377	.373	.376	.376		
I	0.490	0.510		.504	.505	.507	.506		
J	1.174	1.184		1.177	1.178	1.179	1.179		
K	0.558	0.578		.574	.572	.577	.576		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.499	2.500	2.500		
O	3.869	3.879		3.872	3.871	3.874	3.874		
P	0.115	0.135		.125	.125	.123	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.251	.251		
S	0.115	0.135		.125	.133	.126	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.966	2.960	2.960		
V	0.230	0.250		.239	.237	.239	.240		
W	0.115	0.135		.126	.127	.127	.124		
X	0.308	0.313		.311	.312	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.358	.362	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.633	.633	.633	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.245	.244	.245		
AE	1.375	1.395		1.387	1.389	1.394	1.391		
AF	0.115	0.135		.120	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.244	.241	.242	.241		
AI	2.000	2.020		2.003	2.005	2.009	2.002		
AJ	0.023	0.043		.023	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	09/04/09

Audited by:	JL
Date:	09/04/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46432	
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<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	210	211	412		
A	0.438	0.443		.439	.440	.438	.440		
B	1.745	1.755		1.746	1.746	1.746	1.747		
C	3.495	3.505		3.499	3.499	3.500	3.500		
D	1.745	1.755		1.745	1.746	1.746	1.746		
E	7.990	8.010		8.005	8.005	8.004	8.006		
F	0.490	0.510		.508	.502	.508	.509		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.502	.500	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.569	.565	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.124	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.250	.251	.252		
S	0.115	0.135		.127	.126	.130	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.956	2.956		
V	0.230	0.250		.240	.242	.241	.243		
W	0.115	0.135		.125	.126	.126	.124		
X	0.308	0.313		.310	.310	.310	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.369	.366	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.630	.629	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.244	.245	.245	.250		
AE	1.375	1.395		1.393	1.393	1.394	1.391		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.244	.245	.245	.251		
AI	2.000	2.020		2.002	2.003	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: J.L. / mmp  
Date: 09/04/09 / 09/04/13

Audited by: [Signature]  
Date: 09/04/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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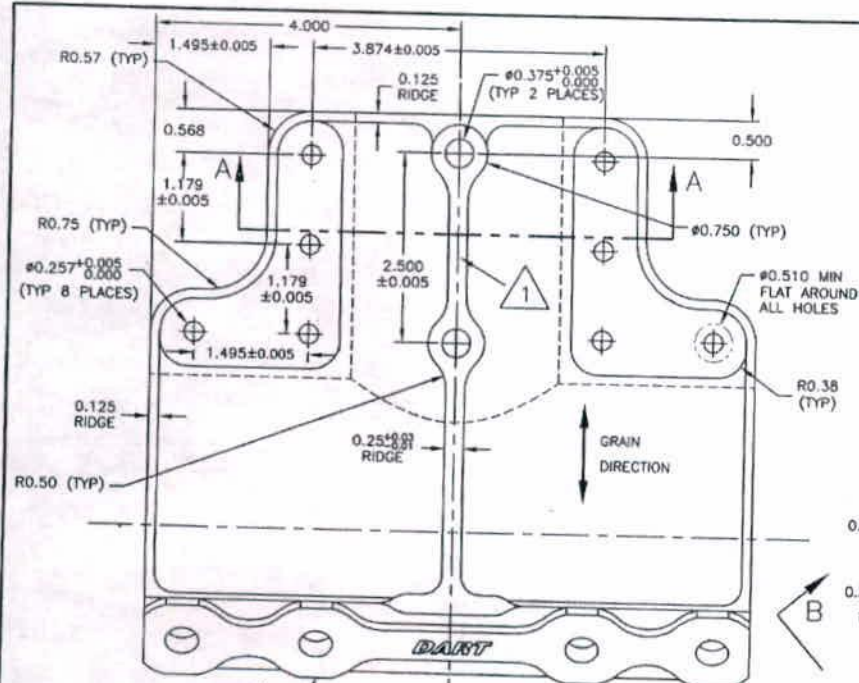
RELEASED

05-12-06

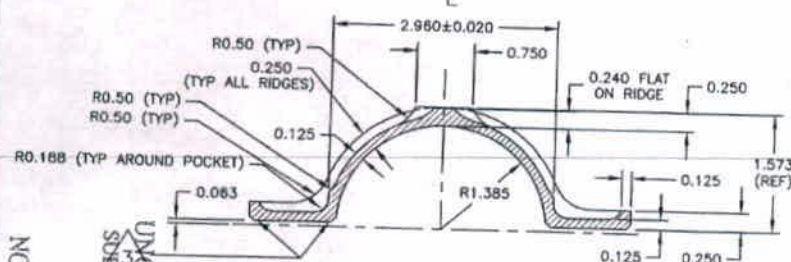
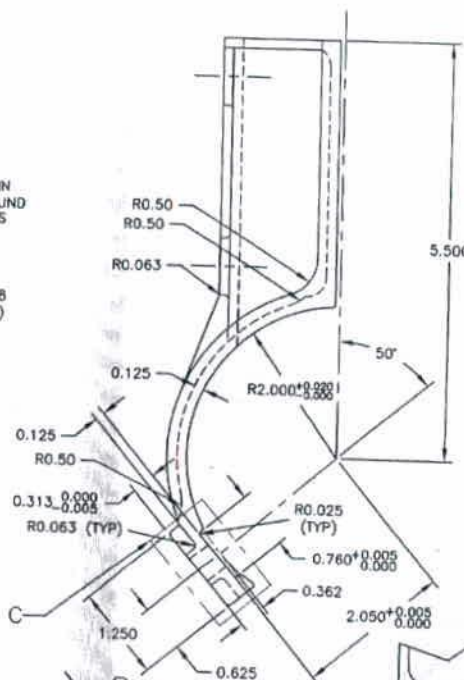
## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  
 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
 4 CHAMFER 0.063" x 45° ALL AROUND  
 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

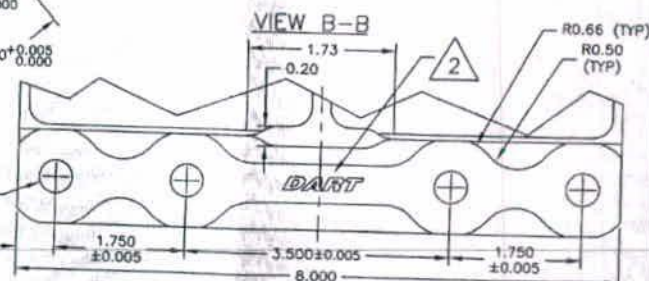


DETAIL C



SECTION A-A

DETAIL C  
 SCALE 4:3



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2571
		TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

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